

Technical Data Sheet

E3 Clearcoat #6801 is an acrylic urethane clearcoat that can be used with all solvent-based and water-based basecoats. It is suitable for automotive refinishing as well as trucks and equipment.

SUITABLE SUBSTRATES

Substrate		Substrate		Substrate	
Solvent-borne Basecoat	✓	Waterborne Basecoat	✓	Acrylic Lacquer	
1K Enamel		2K Enamel	✓		
OEM Finish & Old Paint Work - Reversible		OEM Finish & Old Paint Work - Non-Reversible	✓		

MIXING



By Volume: 4 parts 6801 E3 Clearcoat
1 part 6800 Series Activators
Optional: Up to 10% 6700 or 6700-F Series Urethane Grade Reducer*

Pot Life 4 hours (@70°F (21°C) and 50% relative humidity)

* Use reducer according to shop conditions. Using reducers other than Zero VOC Urethane Grade Reducers will increase VOC.

FLASH TIMES/DRY TIMES



Flash Between Coats 3-15 minutes
Dust Free 10-40 minutes
Dry to Sand 2-10 hours
Delivery 6-12 hours MIN
Force Drying 20 minutes @ 140°F (25°C) without purging

Activator	Flash Time	Dust Free
6854 Lightning	3-5 min	10-15 min
6874/6877 Spot & Panel	5-10 min	15-20 min
6894 Overall	5-15 min	20-30 min
6894HT/6897HT Hi Temp	10-15 min	20-40 min

SURFACE PREPARATION



Tack surface thoroughly before application.

SPRAY GUN SET-UP/APPLICATION



Gun Type HVLP/LVLP Gravity Feed
Fluid Tip 1.2 - 1.4 1.2 - 1.4
Air Pressure 10 PSI @ aircap 25 - 35 PSI @ gun inlet
Mil Thickness: 2-3 coats (@ 1.2 mils per coat dry film thickness). Must have a minimum of 2.2 mils.

LIMITATIONS & PRECAUTIONS

- For use only by professional, trained painters. Not for sale to or use by the general public.
- Before use, read and follow all TDS, label and SDS precautions.
- See next page for more detailed production application.

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SPRAY GUN SET-UP

Gun Type	Siphon Feed	Gravity Feed	Pressure Feed	HVLP/LVLP
Fluid Tip	1.4-1.6 mm	1.2-1.4 mm	1.0-1.2 mm	1.2-1.4 mm
Air Pressure	35-45 PSI (@gun)	25-35 PSI (@ gun)	40-50 PSI (@ gun)	10 PSI (@ aircap)
Fluid Pressure	N/A	N/A	8-10 PSI	N/A

Always refer to gun manufacturer's recommendation for proper set up and spray pressure.

SURFACE PREPARATION

Tack thoroughly before application.
For blending clearcoat refer to SOP #513 and # 514.

ADDITIVES

Additives: Kicker (6417) - Can be used at a rate of ½ oz per sprayable quart.
Appearance Improver (6487) - Can be used at a rate of 1-2 oz per sprayable quart.
Fisheye Remover (6737) - Can be used at a rate of ½ oz per sprayable quart.
Universal Urethane Flex Additive (9194) - Use with soft, flexible substrates. Refer to TDS for mixing information.

APPLICATION & FILM BUILD

Apply 2 - 3 flowing coats using the spray gun setting listed above. Flash for 3 – 15 minutes depending on activator used (refer to flash/dry times on page one). Keep spray gun nozzle 6 - 10 inches from the vehicle to avoid entrapment of air in paint film. Always keep containers tightly closed to prevent moisture contamination. Clean equipment thoroughly after use.

Critical Recoat Time: Do not flash for more than 1 hour between coats. If more than 1 hour @ 70°F (21°C) is reached, wait at least 5 hours before applying for clearcoat or basecoat. Lightly scuff surface and degrease before application.

Film Build: 2-3 coats @ 1.2 mils. Must have a minimum of 2.2 mils and not to exceed 3.6 mils.

PRODUCT SPECIFICATIONS

Weight per gallon: 9.44	Shelf Life: 1 year
RTS Solids by Weight: 33%	Color: Clear Liquid
Approximate Coverage: 510-518 ft ² /gal @ 1 mil	Size: Gallon (6801)

REGULATORY

Category: Clearcoat	6801	6854	6874/6877	6894	6894HT
VOC Actual	0.30#/gal (35 g/l)	3.5#/gal (420 g/l)	3.4#/gal (407 g/l)	3.52#/gal (422 g/l)	3.5#/gal (419 g/l)
VOC Regulatory	0.91#/gal (109 g/l)	3.65#/gal (437 g/l)	3.72#/gal (446 g/l)	3.63#/gal (435 g/l)	3.65#/gal (438 g/l)
Weight % of Volatiles	71.16	46.98	49.93	46.20	46.20
Weight % of Water	0	0	0	0	0
Weight % of Exempt Compounds	68.03	5.20	11.00	4.00	5.50
Volume % of Exempt Compounds	67.37	3.92	8.62	3.00	4.25
Density of Material #/gal	9.44	8.39	8.73	8.34	8.59
		with 6854	with 6874/6877	with 6894	with 6894HT
Ready to Use (less water, less exempt compounds)		2.07#/gal (248 g/l)	2.06#/gal (247 g/l)	2.07#/gal (248 g/l)	2.07#/gal (248 g/l)